

Date: Wednesday, 1/23/2008 12:05:51 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MIRROR BRACKET RH
Job Number	: 36938		
Estimate Number	: 10147		
P.O. Number	:	Part Number	: D20132
This Issue	: 1/23/2008 S.O. No. :	Drawing Number	: D2013 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: C
Previous Run	: 36467A02	Material	:
Written By	:	Due Date	: 1/30/2008 Qty: 5 Um: Each
Checked & Approved By	: <u>1080123</u>		
Comment	: Est Rev:A New Issue 05-11-01 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 2.0447 f(s)/Unit Total : 10.2233 f(s)
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing
 (M304TR0.750W.049)
 Batch: M 107098

SB 08/02/12

5

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

- 1-Punch as per template D2013-T1 and Dwg D2013
- 2-Flatten ends of D2013-2 tube as per Dwg D2013 using DT8545
- 3-Bend (1) tube as per Dwg D2013 using Jig DT8201 identify as D2013-2.
- 4-Deburr as required

SB 08/02/12
 08/02/14 5

FF 08-02-19

5

5

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08-02-20 5

4.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/02/20

5

Job Completion



5241

08/02/20 5

2008/2/20

u 5

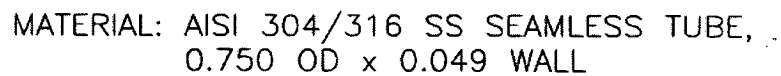
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 2 Date: 28/05/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

KE 99.06.10



38°

QA COPY
02/10/85

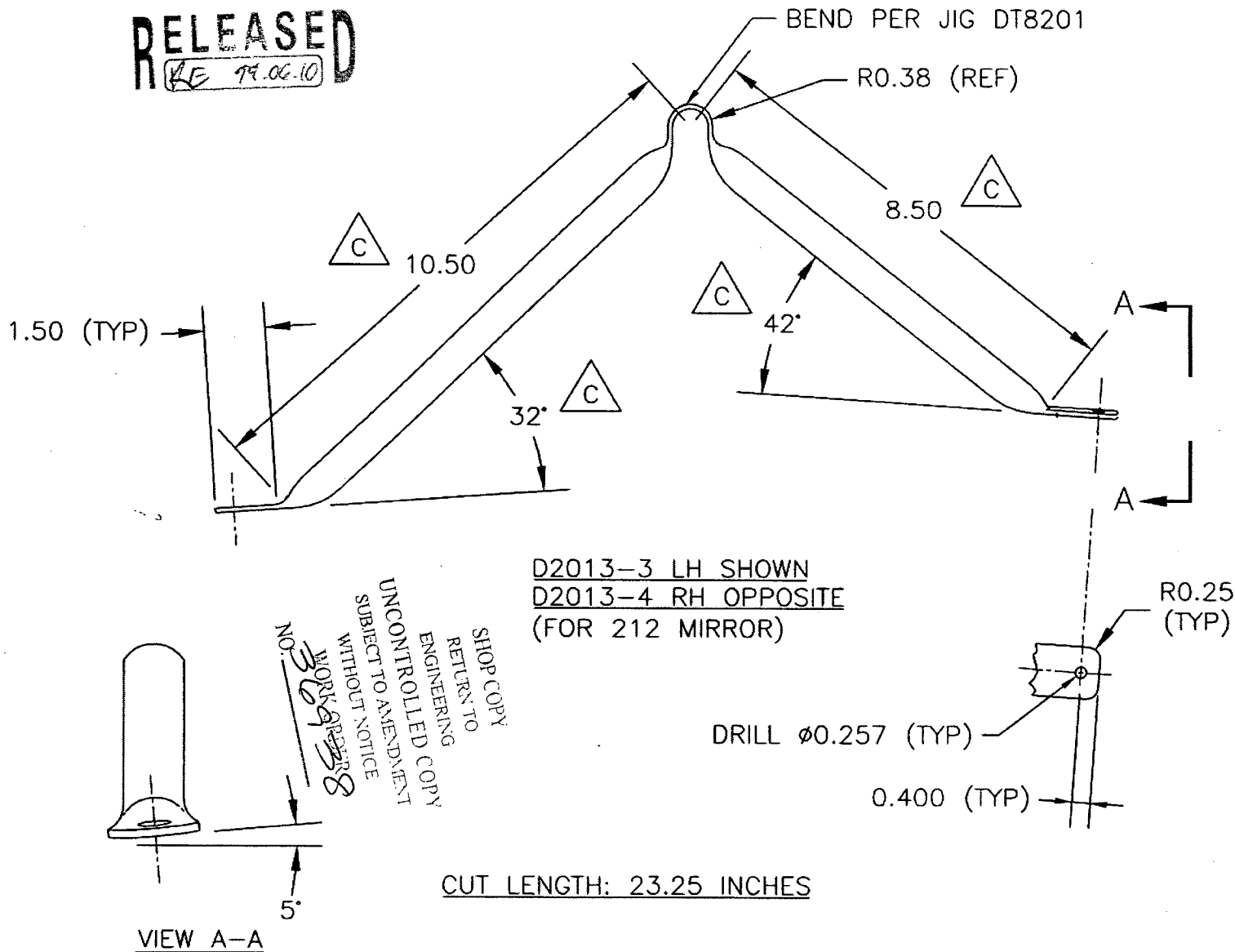
Copyright 1990 by DART AEROSPACE LTD

RELEASED
RE 79.06.10

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. C
JB	RF		
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 3
KE	[Signature]	D2013	
DATE	TITLE	SCALE	NTS
99.06.07	MIRROR BRACKET		



D2013-3 LH SHOWN
D2013-4 RH OPPOSITE
(FOR 212 MIRROR)

NO. 36938
WORK AREA 8
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

CUT LENGTH: 23.25 INCHES

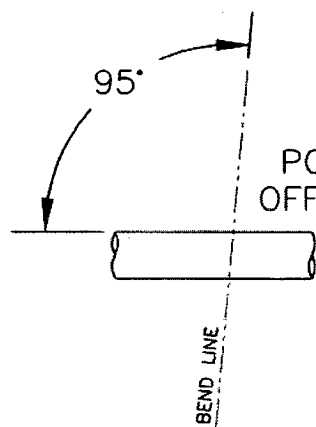
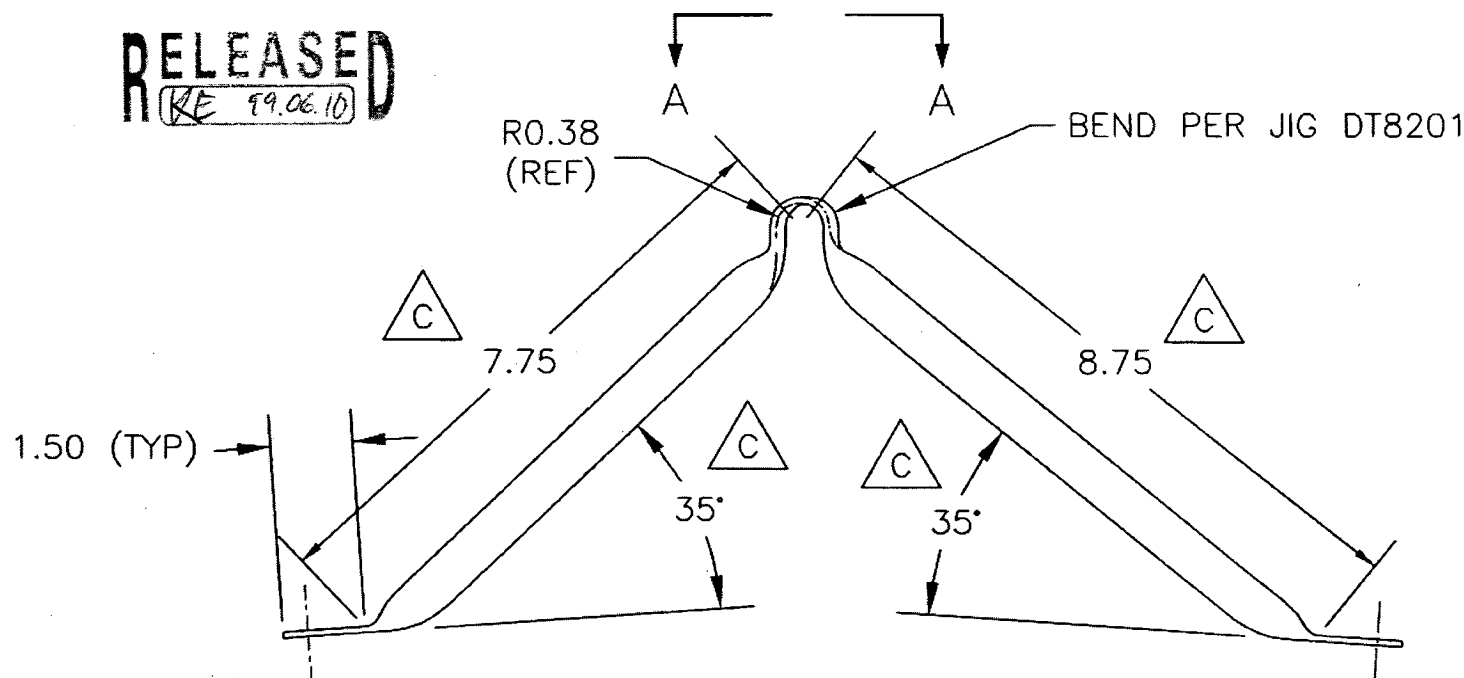
MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

RELEASED
KE 99.06.10

DART

ISSUED
COPY

DESIGN	JB	DRAWN BY	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	KE	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C
				SHEET 3 OF 3
				SCALE
				NTS



VIEW A-A

POSITION TUBE
OFFSET 5
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 36938
WORK ORDER
NO. 36938

D2013-5 LH SHOWN
D2013-6 RH OPPOSITE
(FOR 204 MIRROR)

CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

DRILL $\varnothing 0.257$ (TYP)

0.400 (TYP)

